Work Order ID 58056

April 22, 2010 11:56:52 AM

Item ID: D2989-043 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 30/04/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 10-4-22 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2989	Rev D								
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
Large Fab	1- assemble all ribs in DT9446 jig, weld as per dwg D2989 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 A/R ER316 S.S. Rod Batch: 111679								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00							

GPC 10.06.01

AD 10.06.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 58056

April 22, 2010 11:56:52 AM

Item ID: D2989-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 30/04/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	1- Plug holes prior to powder coating								

4 Pressure Wash

Sub 10/06/03

=> MH 10/06/03

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT
START TIME: 1400pm
OVEN TEMPERATURE: 400°C
FINISH TIME: 1:30pm
********** 2nd coat if necessary **********
2ND COAT:
START TIME: 1:45pm
OVEN TEMPERATURE: 400°C
FINISH TIME: 2:15pm

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 58056

April 22, 2010 11:56:52 AM

Item ID: D2989-043 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 30/04/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: 6-A w/o 58942	0.00							
Packaging	**Memo**	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/06/07

10/06/07

10/06/08

MF
10-6-7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 11:56:56 AM

4

Work Order ID: 58056

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Required Date:** 30/04/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

D2221-1 Rib	Manufactured	No		100	Each	3.0000	1.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	3	
57182	3	

B57499 → (1)

D2989-3 Rib	Manufactured	No		100	Each	1.0000	1.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	1	
57420	1	

B59034 → (1)

D2989-4 Rib	Manufactured	No		100	Each	1.0000	1.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	1	
57421	1	

B57996 → (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 11:56:56 AM

Work Order ID: 58056

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Start Date: 22/04/2010 **Required Date:** 30/04/2010

Start Qty: 1.00 **Required Qty:** 1.00

D2989-5 Rib	Manufactured	No		100	Each	4.0000	2.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	4	
57596	4	

D3182-1 Hinge	Manufactured	No		100	Each	10.0000	2.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	10	
57602	10	

D3442-3 Shim	Manufactured	No		100	Each	14.0000	2.0000

Warehouse / Location	Loc Qty	Loc Code
Main Warehouse		
WA	14	
53137	4	
56204	10	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 11:56:56 AM

Work Order ID: 58056

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Required Date:** 30/04/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

D3827-041 Rib Assembly (Inboard)	Manufactured	No		100	Each	6.0000	1.0000

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	6	
57219	6	

D3832-5 Mesh (Lid)	Manufactured	No		100	Each	3.0000	1.0000

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	3	
57603	3	

D3833-5 Mesh (Lid End)	Manufactured	No		100	Each	17.0000	2.0000

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	17	
53722	11	
57627	6	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 22, 2010 11:56:56 AM

Work Order ID: 58056

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 22/04/2010 **Required Date:** 30/04/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

D3838-041	Manufactured	No	100	Each	3.0000	1.0000

Rib Assembly (Basket Lid, LH)

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	3	
57422	1	
57831	2	

D3838-042	Manufactured	No	100	Each	3.0000	1.0000

Rib Assembly (Basket Lid, RH)

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	3	
57423	1	
57832	2	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

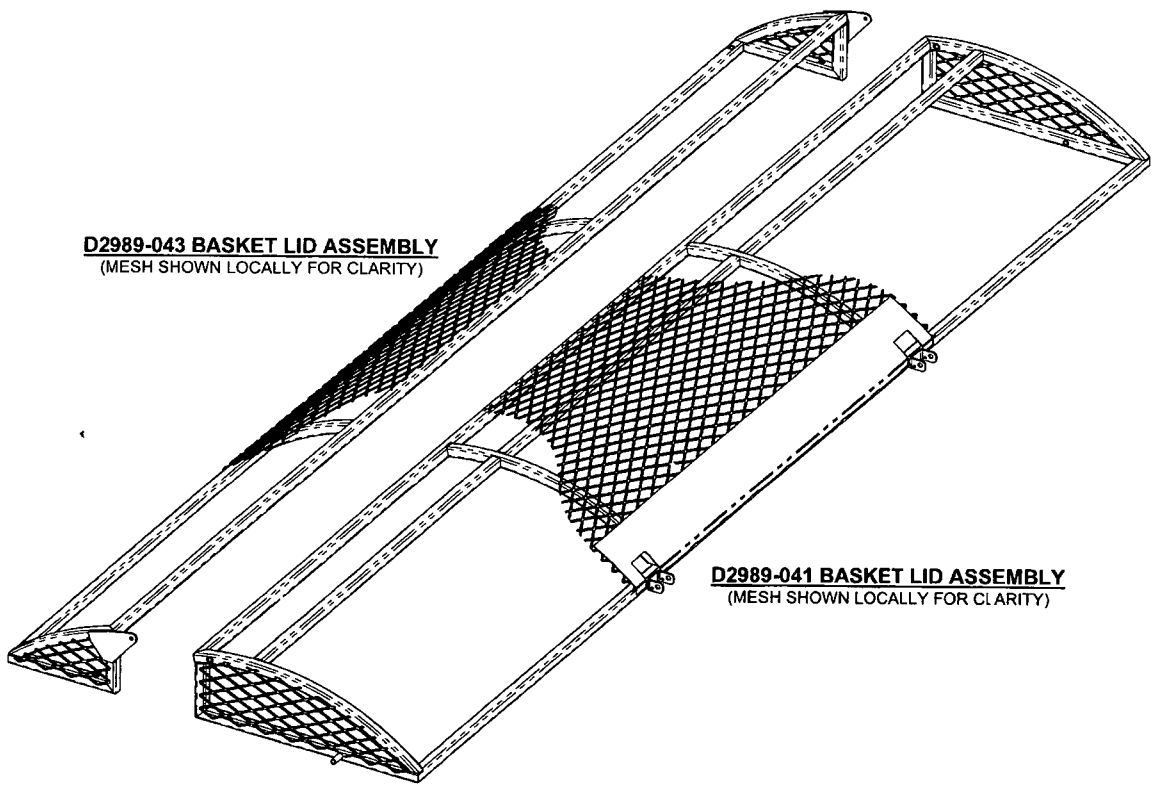
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		**D2989-041**	**BASKET LID ASSEMBLY**
2		X	**D2989-043**	**BASKET LID ASSEMBLY**
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18 MB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 580554
BS 10-4-22

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2989 REV. D
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY
DE APPR.		SCALE NTS
DATE	08.09.24	

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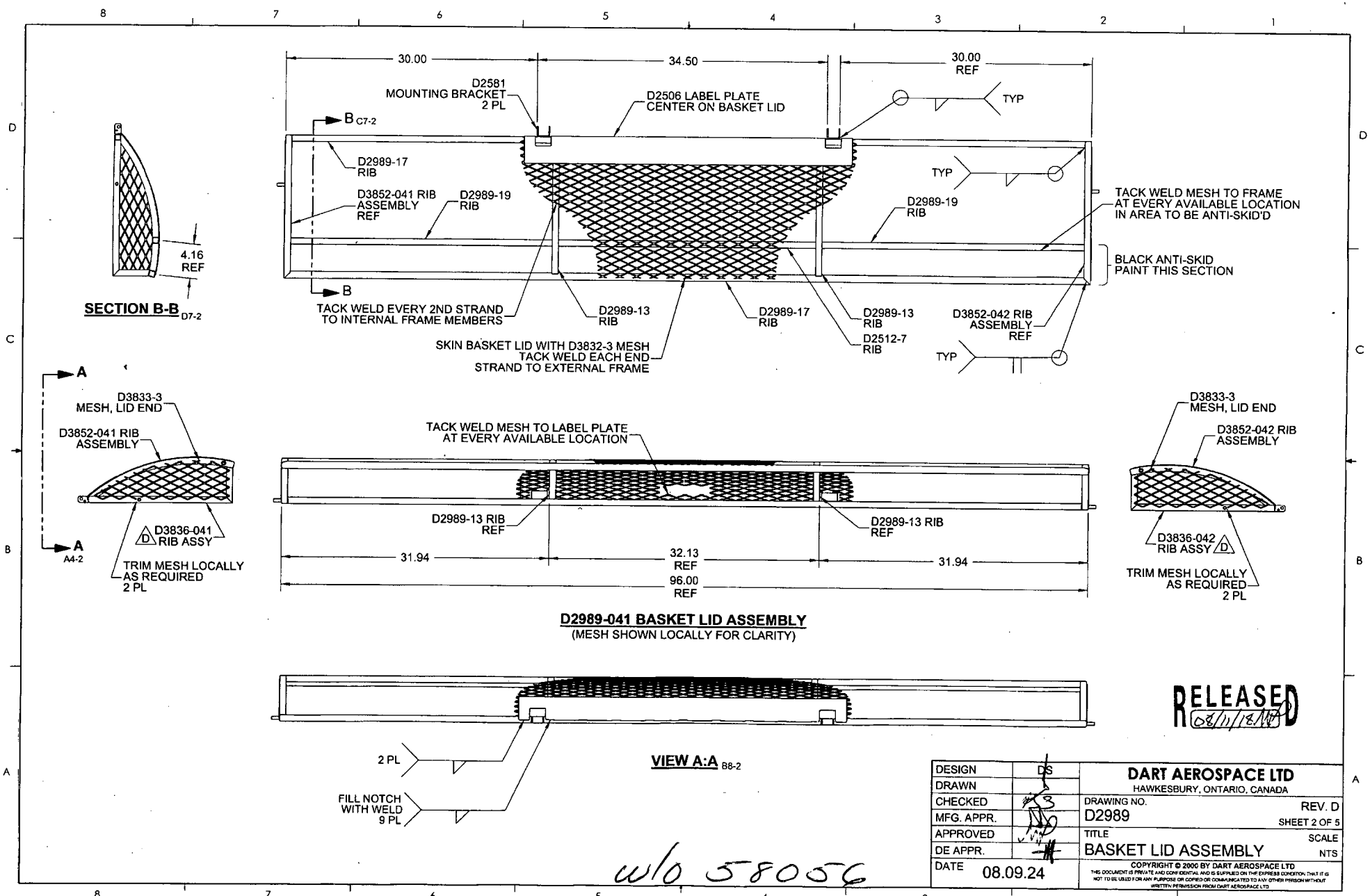
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



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08/11/18

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2989 REV. D
CHECKED		SHEET 2 OF 5
MFG. APPR.		TITLE BASKET LID ASSEMBLY
APPROVED		SCALE NTS
DE APPR.		
DATE	08.09.24	

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w/o 580056

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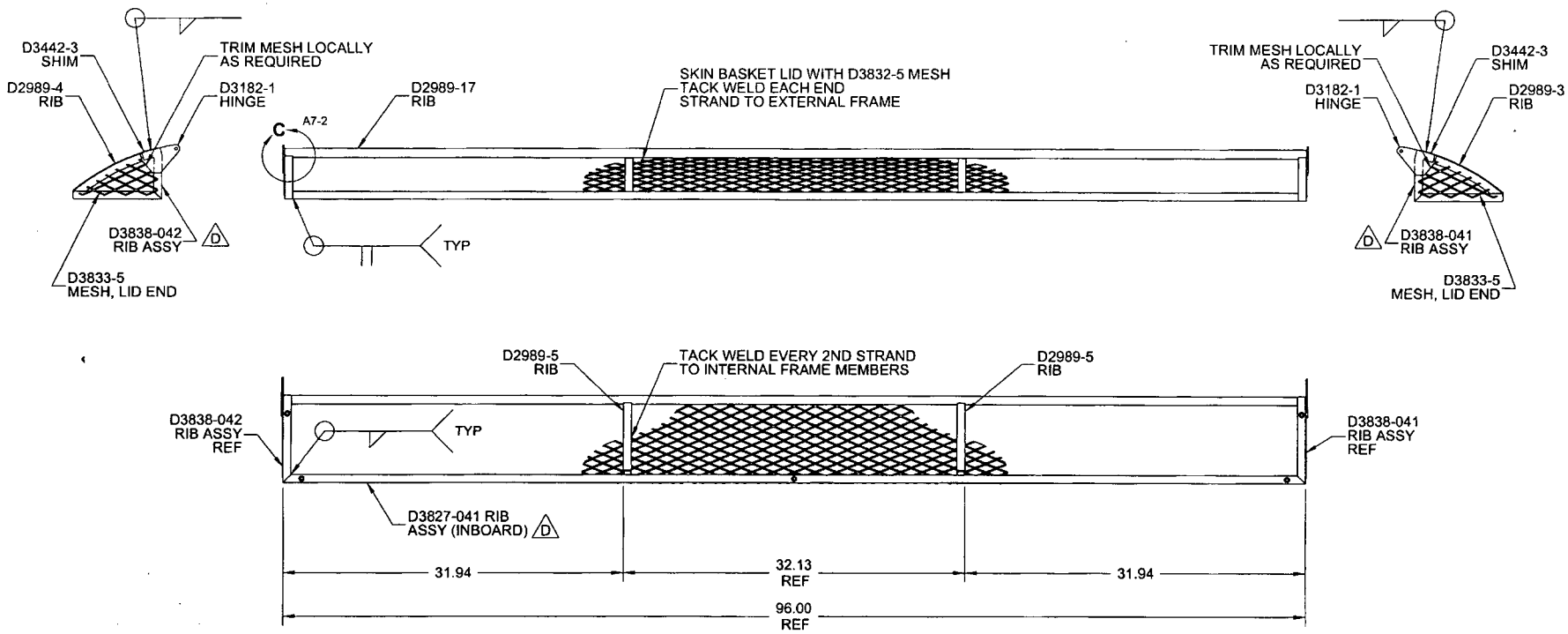
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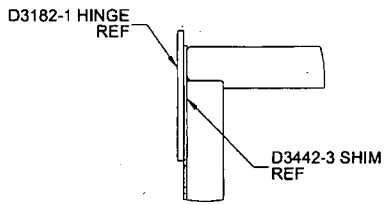
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL C D7-2
TYP, SCALE 4X

RELEASED
05/11/18

DESIGN	DS	**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.			
DATE	08.09.24		

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Dart Aerospace Ltd

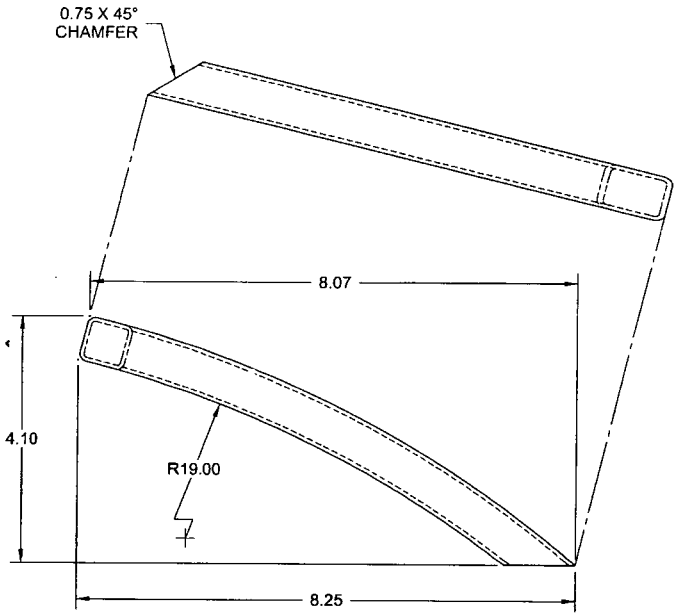
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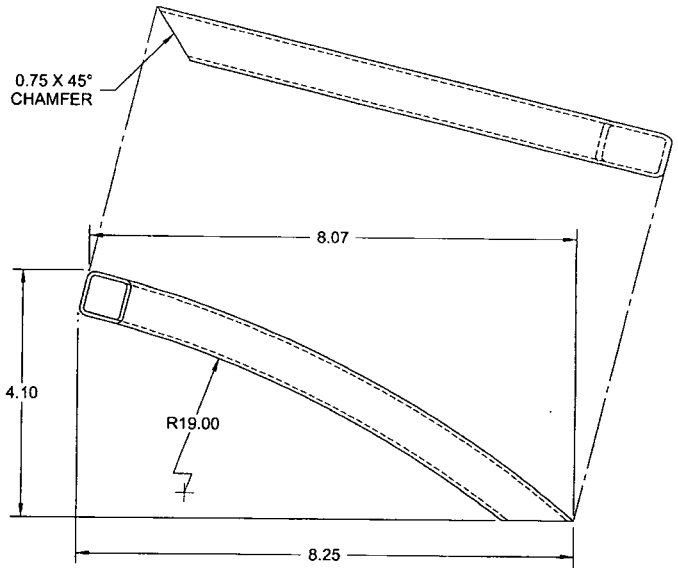
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

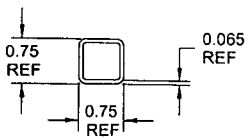
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

NOTES:
1) MATERIAL: D3166-3 BASKET HOOP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

w/o 58056

DESIGN	DS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2989 REV. D
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.09.24	

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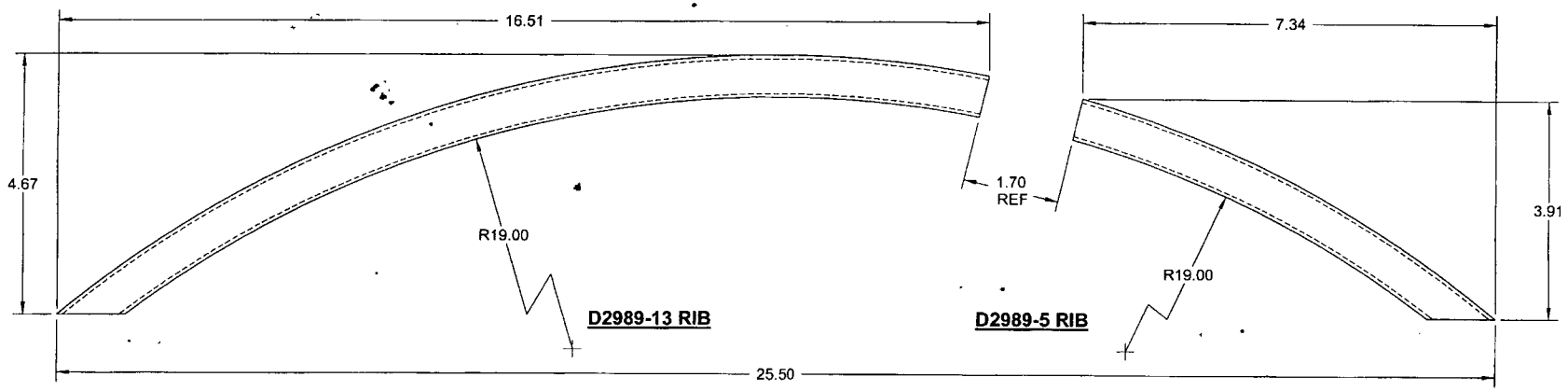
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

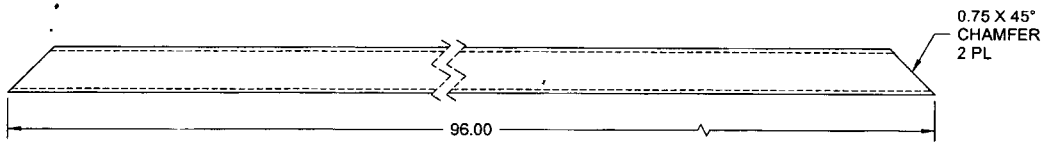
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

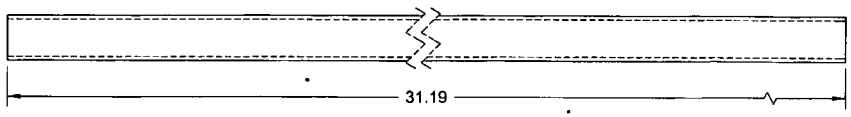


D2989-13 RIB

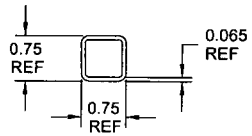
D2989-5 RIB



D2989-17 RIB



D2989-19 RIB



TYPICAL SECTION VIEW

w/o 58056 RELEASED 08/11/18 VM

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.09.24

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2989 REV. D
SHEET 5 OF 5
TITLE BASKET LID ASSEMBLY SCALE NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries